

Work Order ID 53732

November 16, 2009 10:17:09 AM



Page 1

Item ID: D3453-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Clevis

Start Date: 11/16/09

Start Qty: 12.00



Cust Item ID:

Required Date: 11/27/09

Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals:

Process Plan: U

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3453

Rev A

100

0.00



Doosan

Doosan Lathe

Memo

1-Turn as per Folio FA577

Rev: AA

Dwg D3453 Rev: B

2- Deburr as per dwg D3453

0.00

af 09.11.16/
SHOVIN/7

12 *⊗*

150

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

af 09.11.16/
SHOVIN/7

12 *⊗*

160

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

SP 09/11/19
~~*af 09.11.16/*~~
~~*SHOVIN/7*~~

12 *⊗*
~~*12*~~ ~~*⊗*~~
(12)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53732

November 16, 2009 10:17:09 AM

Page 2

Item ID: D3453-1

Accept

Setup Start

Revision ID: B

Stop

Item Name: Clevis

Start Date: 11/16/09 Start Qty: 12.00

Cust Item ID:

Required Date: 11/27/09 Req'd Qty: 12.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: *Carl*

0.00



Packaging

Memo

0.00

Packaging

welding

9/11/19 *(12x) SP*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/20

PL 09-11-20

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

November 16, 2009 10:17:08 AM

Page 1

Work Order ID: 53732



Parent Item: D3453-1RevB



Parent Item Name: Clevis

Start Date: 11/16/09

Required Date: 11/27/09

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R1.250		Purchased	No			100	f	68.1680	3.4560			



304 round bar 1.250

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
. MAT	68.168	
105872	12.5	
108156	11.5	
111018 ✓	44.168	

af 09.11.16

3.58⁺

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 53732
Description: Clevis		Part Number: D3453-1
Inspection Dwg: D3453	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	.440	/			
R0.25	+/-0.030	.250	/			
0.450	+/-0.010	.450	/			
0.625	+/-0.010	.625	/			
0.063 x 45°	+/-0.010 x 0.5°	.063	/			
Ø0.129	+0.005/-0.001	.129	/			
3.26	+/-0.030	3.266	/			
1.00	+/-0.030	1.00	/			
1.550	+/-0.010	1.545	/			
0.500	+0.010/-0.000	.497.503	/			
0.263 x 45°	+/-0.010 x 0.5°	.263	/			
R0.25	+/-0.010	.25	/			
Ø1.13	+0.012/-0.001	1.127	/			
Ø0.500	+0.000/-0.005	.497	/			

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09.11.16	Date: 09/11/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.30	New Issue	KJ/JLM	
B	07.01.17	Dimensions added	KJ/JLM	
C	08.10.09	Diameter symbol removed from 0.500 dimension	KJ/DD	
D	09.11.04	Dimensions updated per Dwg Rev B	KJ	[Signature]

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

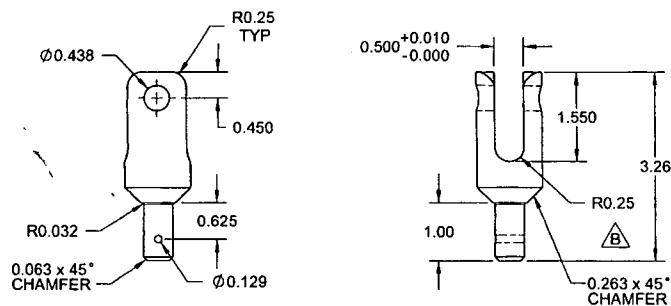
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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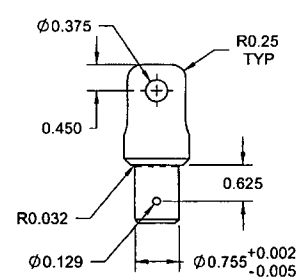
NOTE: Date & initial all entries



W/O 53732



D3453-1 CLEVIS



D3453-3 CLEVIS

RELEASED
07/06/25 JWP

D3453-1/-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3453-1 = 0.41 lbs
D3453-3 = 0.41 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS: R0.25 WAS 0.050 (ZN C5-1, C2-1); 1.220 WAS 1.175 (ZN D1-1); REF PAR 09-018	RF	09.05.21
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3453	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CLEVIS	NTS
DATE	09.05.21	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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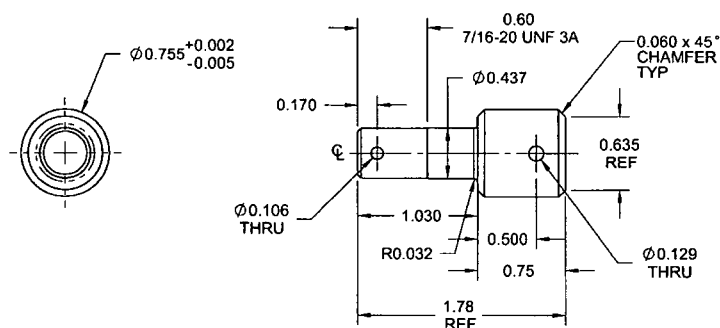
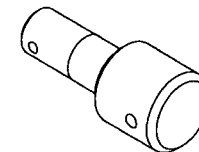
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

WLO 53732



D3453-5 PLUG

RELEASED
21/08/25 11:10

D3453-5 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3453	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CLEVIS	NTS
DATE	09.05.21	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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